

Work Order ID 75106

October-17-11 1:27:23 PM

75106

Page 1

Item ID: D3874-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Floor Protector
 Start Date: 17/10/2011 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 04/11/2011 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/10/17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3874	Rev A								

100 0.00
100
 HandThermo Memo 0.00
 Hand Finishing Thermoforming 1-Cut Sheet to required Blank size

x3 _____ Wh
11/11/02

105 0.00
105
 HandThermo Memo 0.00
 Hand Finishing Thermoforming Dry Sheet as per QSI022 POLYCARBONATE

Temp: 240°F
 Time IN: 7:30 pm
 Time OUT: 11:30 pm

x3 _____ Wh
11/11/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* Thermoform Thermoforming Machine	Memo 1-Machine Set-Up 2-Pre-heat Tool to required temp. 3-Thermoform as per Dwg and Folio #FTA038 using tool DT9474 Dwg Rev: <u>A</u> Folio Rev: <u>B</u>	0.00 0.00				x3			<i>DL</i> 11/11/03
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo Visually inspect part for proper formation and texture	0.00 0.00				x3			<i>Wh</i> 11/11/03
130 *130* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(x3)			<i>B</i> 11/11/03

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Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 17/10/2011 **Start Qty:** 3.00

3

Required Date: 04/11/2011 **Req'd Qty:** 3.00

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Customer:

Reference:

Run Start *NR1*

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140

0.00

140

0.00

HandThermo

Hand Finishing Thermoforming

Memo

1-Trim to finished dimensions as per Dwg

x 5

Whe
11/11/04

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

0.00

QC

Quality Control

Memo

Complete FAI document

4

W
11/1/04

160

QC5- Inspect part completeness to step on W/O

0.00

160

0.00

QC

Quality Control

Memo

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N900040100

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Stop *NS2*

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Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

Identify as per dwg & Stock Location:

0.00

170

Memo

PPD 75110

0.00

Packaging

Packaging

QC21- Final Inspection - Work Order Release

0.00

180

Memo

0.00

QC

Quality Control

MF
11-11-04

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Picklist Print

October-17-11 1:27:28 PM

Page 1

Work Order ID: 75106

75106

Parent Item: D3874-1

D3874-1

Parent Item Name: Floor Protector

Start Date: 17/10/2011

Required Date: 04/11/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev A 09.02.06 New Issue DL
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	1,848.384	4.38	13.14			

MI FXS 118-90318-08

Lexan Sheet

**

Location

Loc Qty

Loc Code

therm

1848.384621

113127

1848.38462

13.14 sq ft.

11/11/03

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	75106
Description: Floor Protector		Part Number:	D3874-1
Inspection Dwg: D3874 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3/16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DL

Date: 11/11/03

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.050	Min	0.093"	✓			
0.065	Min	0.096"	✓			
0.5	Min	0.53"	✓			

Measured by: DL

Date: 11/11/04

Audited by: BB

Date: 11/11/04

Prototype Approval: N/A

Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	<u>AA</u>

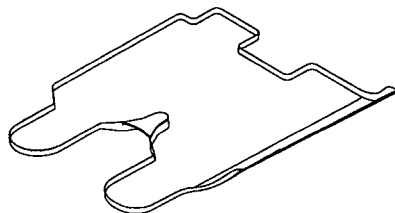
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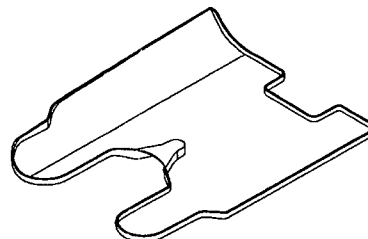
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D3874-1 FLOOR PROTECTOR



D3874-2 FLOOR PROTECTOR

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

NO 75106 M.L.J
11/10/17

RELEASED
21/03/18

A		NEW ISSUE		PH	09.01.29
REV.		DESCRIPTION		BY	DATE
DESIGN	<i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	<i>PH</i>				
CHECKED	<i>PH</i>	DRAWING NO.			REV. A
MFG. APPR.	<i>PH</i>	D3874			SHEET 1 OF 3
APPROVED	<i>PH</i>	TITLE			SCALE
DE APPR.	<i>PH</i>	FLOOR PROTECTOR			NTS
DATE	09.01.29	<small>COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			

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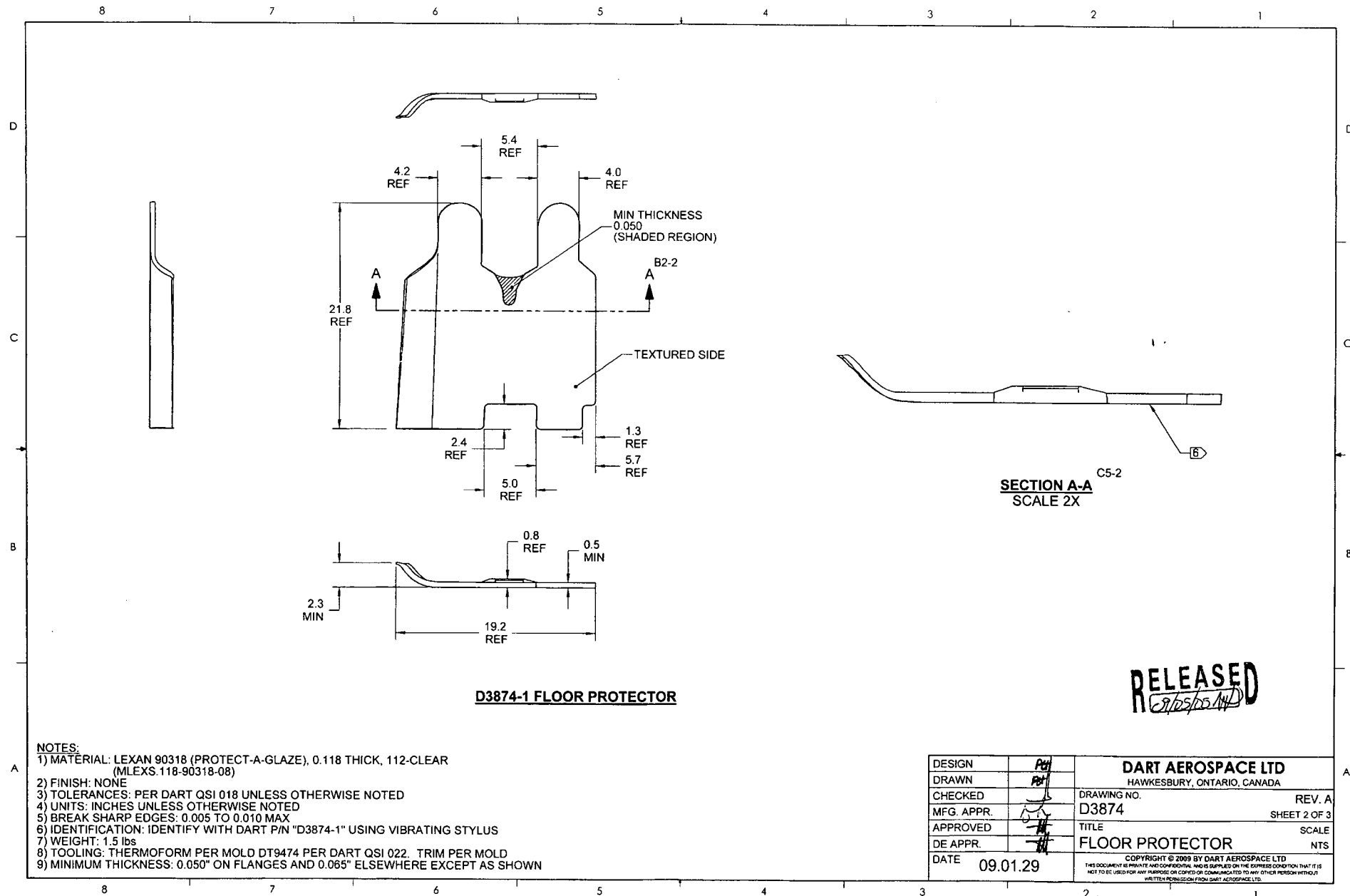
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Dart Aerospace Ltd

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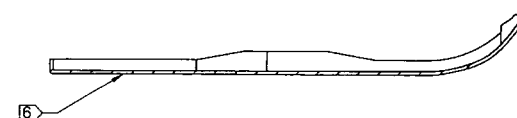
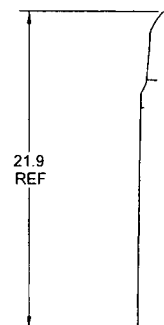
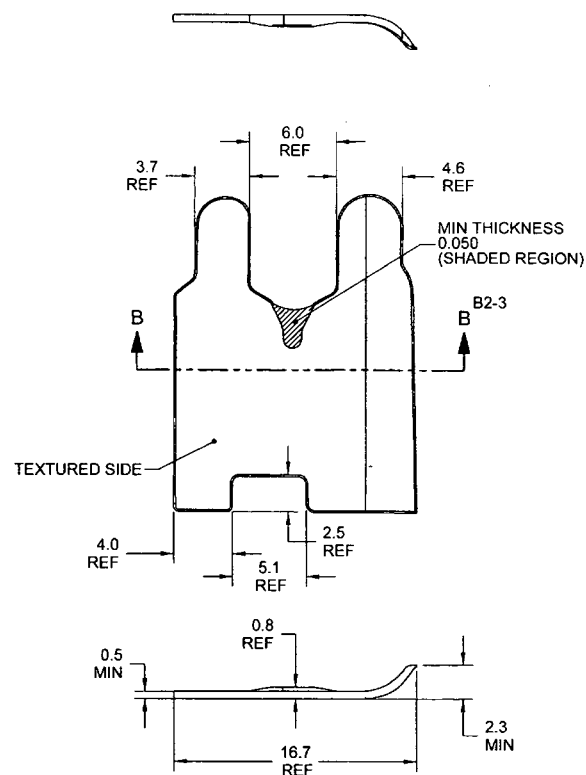
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SECTION B-B
SCALE 2X

D3874-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3874-2" USING VIBRATING STYLUS
- 7) WEIGHT: 1.5 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9474 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.050" ON FLANGES AND 0.055" ELSEWHERE EXCEPT AS SHOWN

RELEASED
2/15/05

DESIGN	AB	DART AEROSPACE LTD	
DRAWN	AB	HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	REV. A
MFG. APPR.	AB	D3874	SHEET 3 OF 3
APPROVED	AB	TITLE	SCALE
DE APPR.	AB	FLOOR PROTECTOR	NTS
DATE	09.01.29	COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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